Dart Aerospace Ltd.

Date: Tuesday, 15/01/2008 12:34:31 PM
User: Linda Lacelle

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services	**Drawing Name**	: FUEL PURGE CANISTER
Job Number	: 36777B		
Estimate Number	: 10442		
P.O. Number	:	**Part Number**	: D32623
This Issue	: 15/01/2008 **S.O. No.** :	**Drawing Number**	: D3262 REV C
Prsht Rev.	: NC	**Project Number**	: N/A
First Issue	: / / **Type** : MACHINED PARTS	**Drawing Revision**	: C
Previous Run	: 35990B	**Material**	:
Written By	: _____	**Due Date**	: 31/01/2008 **Qty:** 12 **Um:** Each
Checked & Approved By	: _____		
Comment	: Est. C 05.03.10 Removed P/O for liquid penetrant inspection K J/JLM		

Additional Product

Job Number:

Seq. #:	Machine Or Operation:	Description :
1.0	M6061T6B0500X06000	6061-T6 Bar .50" x 6.0"

Comment: Qty.: 0.9668 f(s)/Unit Total : 11.6021 f(s)
Material: 6061-T6/T651 (QQ-A-200/8 or 225/8) 0.500" thick
(M6061T6B0.500x06.000)
Identify for D3262-3
Batch: M106858 SN 08/01/31 (12)

2.0	BAND SAW	BAND SAW

Comment: BAND SAW
Cut blanks: 6.000" x 0.500" x 5.400" long Bar
Machine as per Folio FA457 and Dwg D3262
Identify for D3262-3
Deburr SN 08/07/31 (12)

3.0	HAAS1	HAAS CNC VERTICAL MACHINING #1

Comment: HAAS CNC VERTICAL MACHINING #1
Machine as per dwg D3262 SN 08/02/02 (12)

4.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE

Comment: INSPECT PARTS AS THEY COME OFF MACHINE SN 08/02/02 (12)

Form: rprocess

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W/O:		WORK ORDER CHANGES					
DATE	**STEP**	**PROCEDURE CHANGE**	**By**	**Date**	**Qty**	**Approval** Chief Eng / Prod Mgr	**Approval** QC Inspector

Part No: _____ **PAR #:** _____ **Fault Category:** _____ **NCR:** Yes (No) **DQA:** D **Date:** 08/02/04

QA: N/C Closed: _____ **Date:** _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	**STEP**	**Description of NC** Section A	**Corrective Action** Section B			**Verification** Section C	**Approval** Chief Eng	**Approval** QC Inspector
			Initial Chief Eng	**Action Description** Chief Eng	**Sign & Date**			

NOTE: Date & initial all entries

Date: Tuesday, 15/01/2008 12:34:32 PM
User: Linda Lacelle

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services **Drawing Name:** FUEL PURGE CANISTER

Job Number: 36777B **Part Number:** D32623

Job Number:

Seq. #:	Machine Or Operation:	Description :
5.0	QC8	SECOND CHECK
	Comment: SECOND CHECK	08.02.04 (12)
6.0	PACKAGING 1	PACKAGING RESOURCE #1
	Comment: PACKAGING RESOURCE #1 Identify and Stock Location:_____ BARclay 2/4 (12)	
7.0	QC21	FINAL INSPECTION/W/O RELEASE
	Comment: FINAL INSPECTION/W/O RELEASE	(12) 2008/02/04

Job Completion 2008/2/04 (12)

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	**STEP**	**PROCEDURE CHANGE**	**By**	**Date**	**Qty**	**Approval** Chief Eng / Prod Mgr	**Approval** QC Inspector

Part No: _____ **PAR #:** _____ **Fault Category:** _____ **NCR:** Yes No **DQA:** _____ **Date:** _____

QA: N/C Closed: _____ **Date:** _____

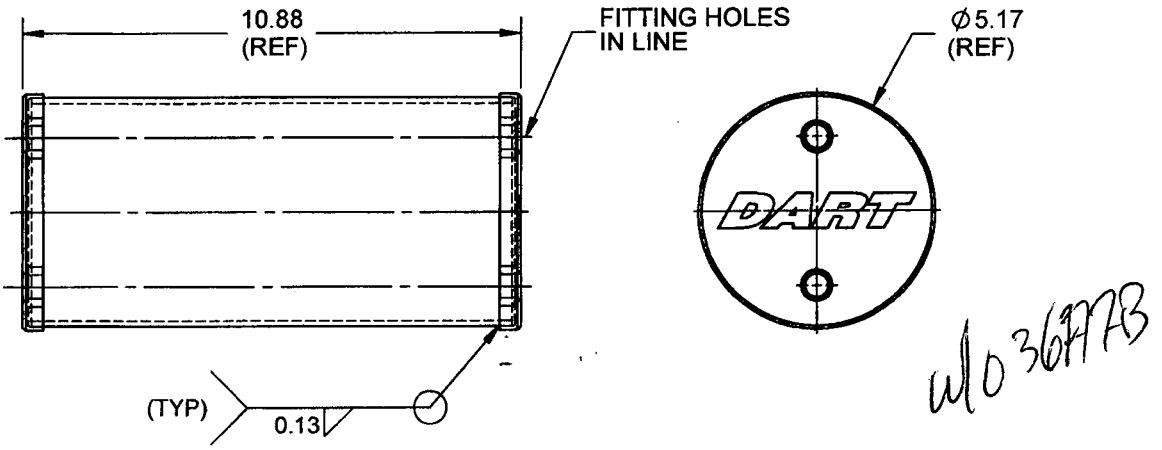
NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	**STEP**	**Description of NC** Section A	**Corrective Action** Section B			**Verification** Section C	**Approval** Chief Eng	**Approval** QC Inspector
			Initial Chief Eng	**Action Description** Chief Eng	**Sign & Date**			

NOTE: Date & initial all entries

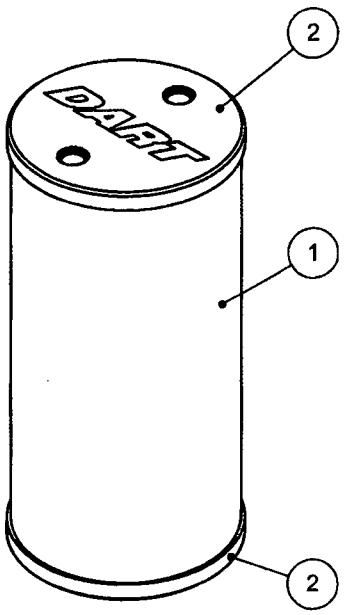
DESIGN RF	DRAWN BY JB	**DART AEROSPACE LTD** HAWKESBURY, ONTARIO, CANADA	
CHECKED PH	APPROVED RF	DRAWING NO. D3262	REV. C SHEET 1 OF 2
DATE 06.08.31		TITLE FUEL PURGE CANISTER	SCALE 1:4

REV	DATE	DESCRIPTION
A	04.05.06	FIRST ISSUE
B	05.02.14	ADD PRESSURE TESTING OPTION
C	06.08.31	⌀5.165 WAS ⌀5.190

RELEASED
06.09.19 RF



W/O 369773

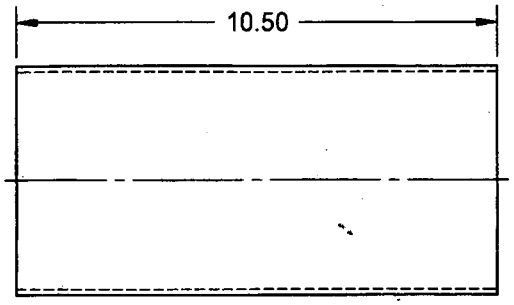


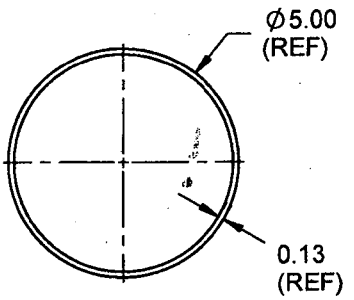
D3262-041 CANISTER ASSEMBLY

ITEM	QTY -041	P/N	DESCRIPTION
	X	D3362-041	CANISTER ASSEMBLY
1	1	D3262-1	TUBE
2	2	D3262-3	CAP

NOTES:
1) WELD PER DART QSI 004
2) BREAK ALL SHARP CORNERS 0.005 TO 0.010
3) LIQUID PENETRANT INSPECT PER ASTM E1417 LEVEL 1 OR PRESSURIZE TO 10 psi AND SUBMERGE UNDER WATER TO (B) CHECK FOR LEAKS
4) FINISH: CHEMICAL CONVERSION COAT PER QSI 005 4.1
   POWDER COAT ASSEMBLY WHITE (4.3.5.1) PER DART QSI 005 4.3
5) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
6) ALL DIMENSIONS ARE IN INCHES UNLESS OTHERWISE NOTED
7) IDENTIFY WITH DART P/N AND B/N USING FINE POINT PERMANENT INK MARKER

DESIGN	DRAWN BY	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED PH	APPROVED	DRAWING NO. D3262	REV. C SHEET 2 OF 2
DATE 06.08.31		TITLE FUEL PURGE CANISTER	SCALE 1:4

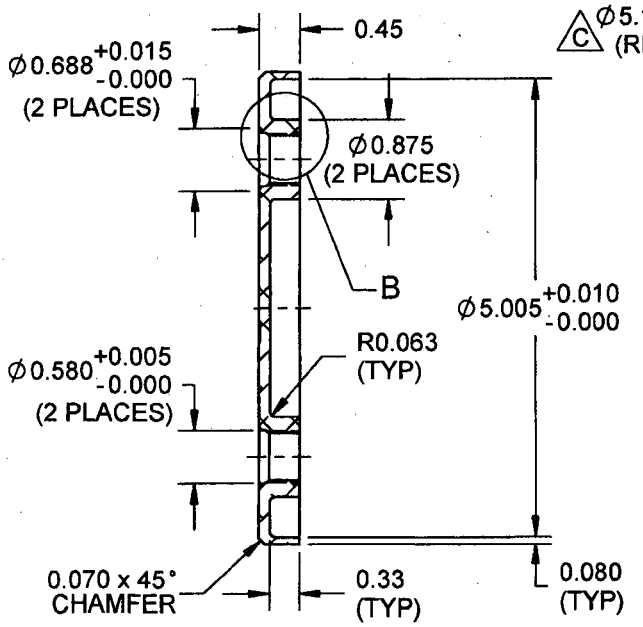




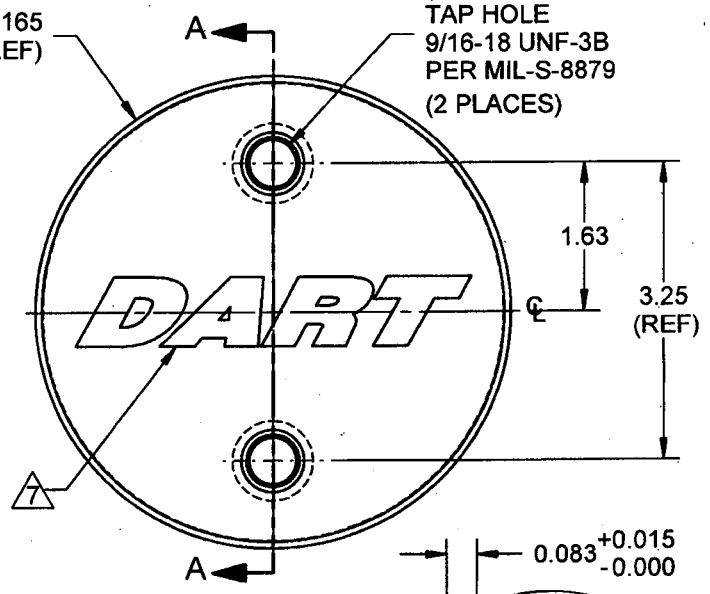
RELEASED
dc.09.19

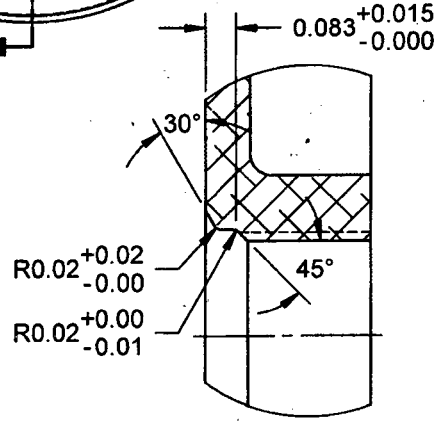
D3262-1 TUBE

1) MATERIAL: 6061-T6 OR 6061-T62 TUBING, 5.00 OD x 0.125 WALL
PER WW-T-700/6 OR AMS 4080 OR AMS 4082 OR
QQ-A-200/8 OR QQ-A-225/8
(REF. DART SPEC. M6061T6T5.000W.125)



SECTION A-A
SCALE 1 : 2





DETAIL B
SCALE 2 : 1

D3262-3 CAP

1) MATERIAL: 6061-T6/T651 (QQ-A-200/8 OR QQ-A-225/8) BAR
(REF. DART SPEC. M6061T6B)

NOTES:
2) FINISH: NONE
3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
4) ALL DIMENSIONS ARE IN INCHES UNLESS OTHERWISE NOTED
5) BREAK ALL SHARP CORNERS 0.005 TO 0.010
6) PART IS SYMMETRICAL ABOUT CENTERLINE
7) ENGRAVE 'DART' LOGO AS SHOWN USING 0.75 HIGH x 0.010 DEEP
(MAX) LETTERS WITH TOOL RADIUS OF 0.25 (MIN)

DART AEROSPACE LTD	Work Order:	36777
Description: CAP	Part Number:	D3262-3
Inspection Dwg: D3262 Rev: C		Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

[X] First Article [ ] Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
.45	±.030	.456	✓			
Ø0.688	+.015 −.000	Ø0.690	✓			
Ø0.586	±.005 ±.000	Ø0.581	✓			
.070X45°	±.010	.068X45°	✓			
.33	±.030	.330	✓			
.080	±.010	.079	✓			
R .063	±.010	R .063	✓			
Ø0.875	±.010	Ø.875	✓			
Ø5.005	±.010 −.000	Ø5.007	✓			
Ø5.165	±.010	Ø5.166	✓			
Ø0.516	+.008 −.001	Ø0.520	✓			
3.25	±.030	3.253	✓			
.083	±.015 ±.000	.093	✓			

Measured by:		Audited by:		Prototype Approval:	
Date:	08/02/02	Date:	08.02.02	Date:	

Rev	Date	Change	Revised by	Approved
A		New Issue	KJ/RF	